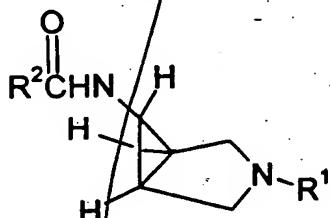


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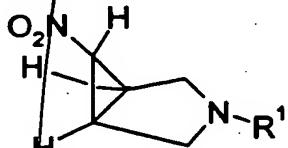
Claims

1. A process for preparing a compound of the formula



wherein

R^1 is benzyl, wherein the phenyl of the benzyl may be substituted by one or more of
10 C_1-C_6 alkyl, C_1-C_6 alkoxy, halo, nitro, amino or trifluoromethyl, and
 R^2 is C_1-C_6 alkyl, trifluoromethyl, or phenyl which may be substituted by one or more
of C_1-C_6 alkyl, C_1-C_6 alkoxy, halo, nitro, amino or trifluoromethyl, which comprises
(a) reducing a compound of the formula



15 wherein R^1 is as defined above, in the presence of iron and a organic solvent under acidic
conditions, and
(b) acylating the compound of formula III formed:

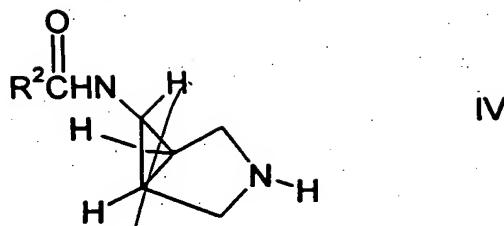


with an acylating agent of the formula $R^2C(O)X$ wherein R^2 is as defined above, and X is a
20 leaving group.

2. A process according to claim 1 wherein the compound of the formula III
formed in step (a) is not isolated before acylation step (b).

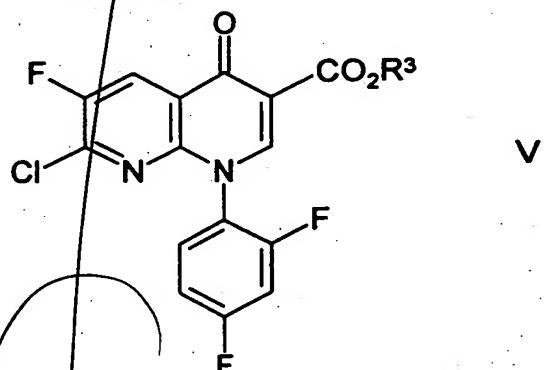
3. A process according to claim 1 or 2 wherein the compound of formula I
wherein R^1 is as defined in claim 1, is subjected to debenzylation to form the compound of the
25 formula

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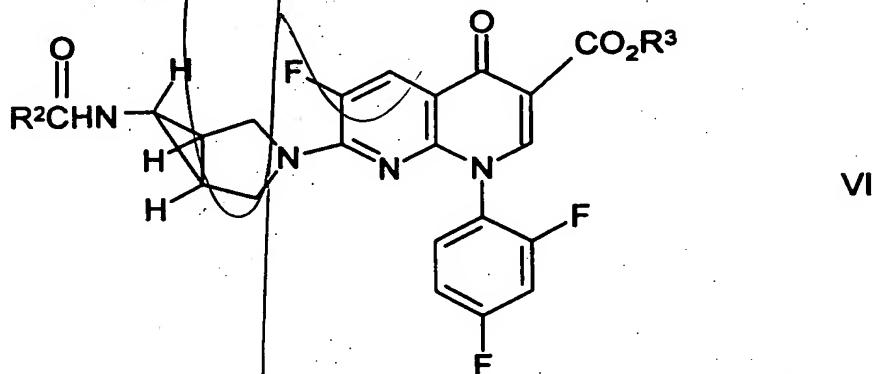


4. A process according to claim 3 wherein the debenzylation is by reaction with hydrogen and palladium catalyst in acetic acid and an organic solvent.

5. A process according to claim 3 or 4 further comprising reacting the compound of formula IV with a compound of the formula

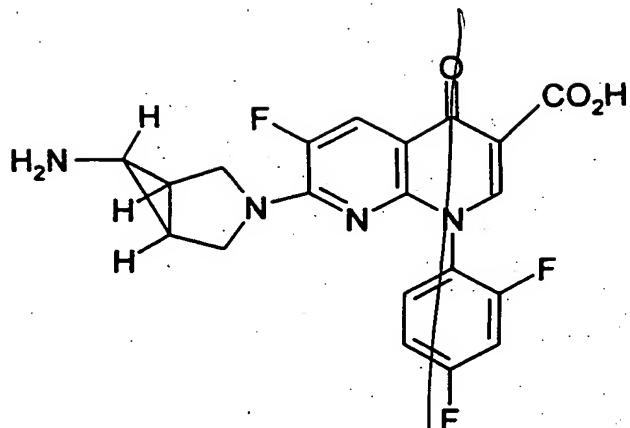


10 wherein R^3 is C₁-C₆ alkyl, to form a compound of the formula



wherein R² is as defined in claim 1

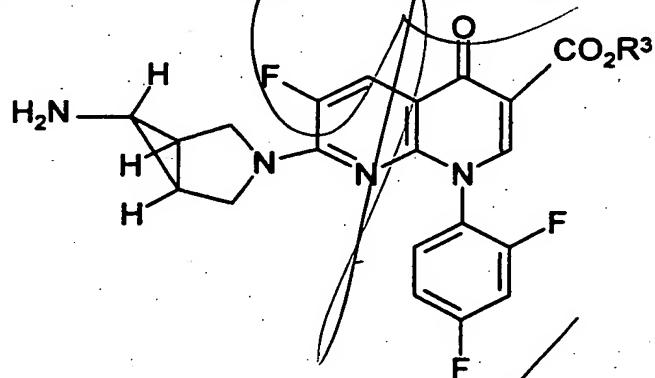
6. A process according to claim 5 further comprising hydrolysis of the compound 15 of formula VI with methanesulfonic acid, water and an organic solvent to form the monomethanesulfonic acid salt of the compound of the formula



VII

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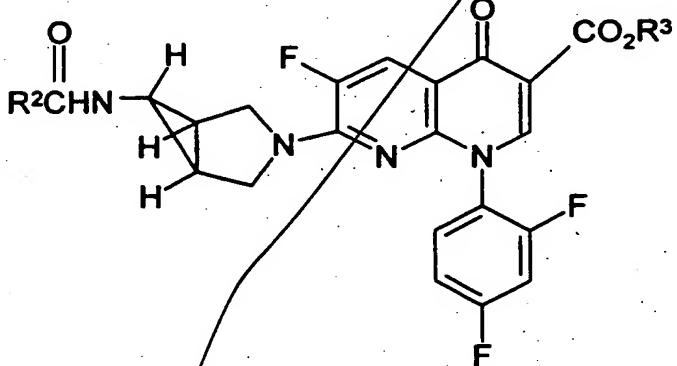
7. A process according to claim 5 or 6 further comprising hydrolysis of the compound of formula VI with methanesulfonic acid and R^3OH wherein R^3 is as defined in claim 5 to form the monomethanesulfonic acid salt of the compound of the formula



VIII

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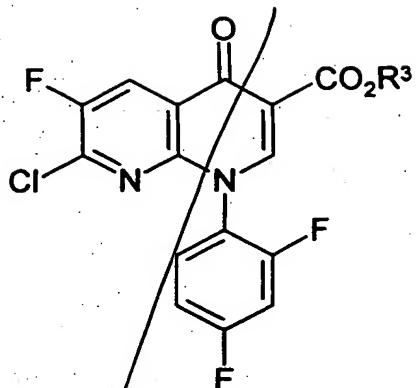
8. A process for the preparation of a compound of the formula



VI

See B1
wherein R^2 is R^2 is C_1-C_6 alkyl, trifluoromethyl, or phenyl which may be substituted by one or more of C_1-C_6 alkyl, C_1-C_6 alkoxy, halo, nitro, amino or trifluoromethyl, and

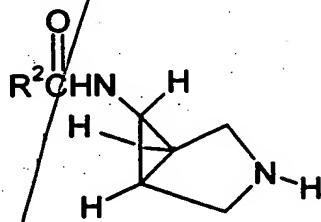
R^3 is C_1-C_6 alkyl, which comprises reacting a compound of the formula



V

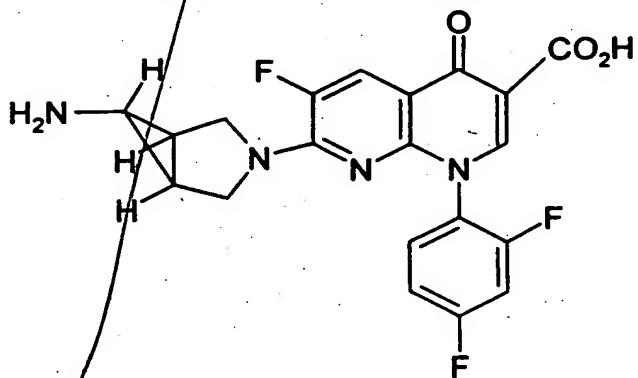
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with a compound of the formula



IV

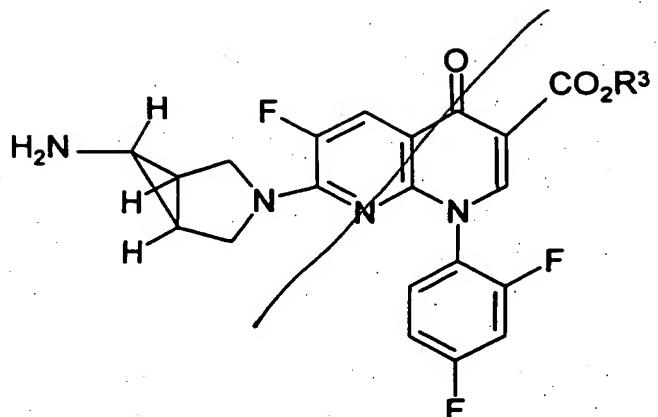
9. A process according to claim 8, further comprising hydrolysis of the compound of formula VI with methanesulfonic acid, water and an organic solvent to form the monomethanesulfonic acid salt of the compound of the formula
10. monomethanesulfonic acid salt of the compound of the formula



VII

10. A process according to claim 8, further comprising hydrolysis of the compound of formula VI with methanesulfonic acid and R3OH wherein R3 is as defined in claim 5 to form the monomethanesulfonic acid salt of the compound of the formula

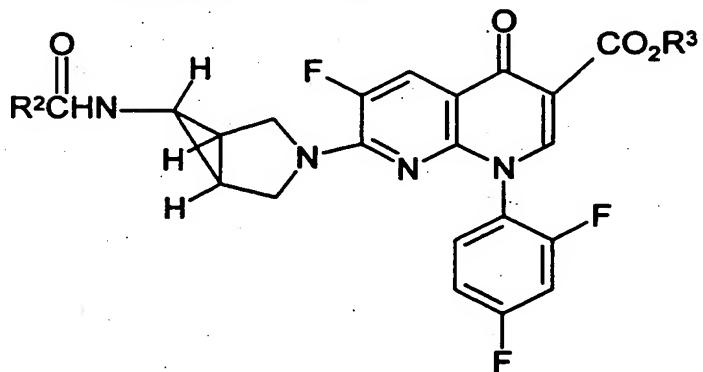
Dick B1



VIII

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11. A compound of the formula



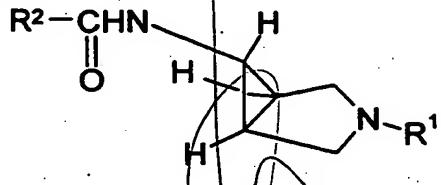
VI

wherein

10 R^2 is $\text{C}_1\text{-C}_6$ alkyl, trifluoromethyl, or phenyl which may be substituted by one or more of $\text{C}_1\text{-C}_6$ alkyl, $\text{C}_1\text{-C}_6$ alkoxy, halo, nitro, amino or trifluoromethyl, and

R^3 is $\text{C}_1\text{-C}_6$ alkyl.

12. A compound of the formula



wherein

15 R^1 is hydrogen or benzyl, wherein the phenyl of the benzyl may be substituted by one or more of $\text{C}_1\text{-C}_6$ alkyl, $\text{C}_1\text{-C}_6$ alkoxy, halo, nitro, amino or trifluoromethyl, and

R^2 is $\text{C}_1\text{-C}_6$ alkyl, trifluoromethyl, or phenyl which may be substituted by one or more of $\text{C}_1\text{-C}_6$ alkyl, $\text{C}_1\text{-C}_6$ alkoxy, halo, nitro, amino or trifluoromethyl.